

Work Order ID 63825

November 15, 2010 1:09:09 PM

ASAP



Page 1

Item ID: D4093-1

Revision ID:

Item Name: Bracket

Start Date: 11/15/10 Start Qty: 2.00

Required Date: 11/17/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4093

A

110

0.00



Waterjet

FLOW CNC Waterjet

Memo

CUT AS DWG

DWG REV: *A*

PROG REV: *A*

DEBURR

0.00

120

QC2- Inspect parts off machine FAI/FAIB

0.00

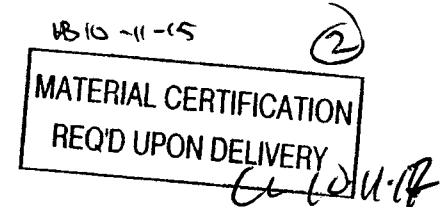


QC

Quality Control

Memo

0.00



B10-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63825

November 15, 2010 1:09:09 PM

Page 2

Item ID: D4093-1

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Start Date: 11/15/10 Start Qty: 2.00

Required Date: 11/17/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Solution

(+2)

132



Small Fab

Small Fab

Memo
DRILL AS PER DWG

0.00

0.00

10/11/16

135



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Solution

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63825

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Item ID: D4093-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 11/15/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



HandFinish

Memo

0.00

0.00

Hand Finishing

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M 115091.

START 2:15

Memo

QUENT. 3200

FINISH 2:45

0.00

0.00

2

BL 10-11-16.

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> 90

10/11/16

2 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63825

November 15, 2010 1:09:09 PM



Page 4

Item ID: D4093-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 11/15/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Packaging

Identify as per dwg & Stock Location: 6A

0.00

w/o 62803 (14)

0.00

w/o 62562 (13)

Memo

EP 11/17 (2)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

A. 10.11.18

U 10.11.17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 15, 2010 1:09:07 PM

Page 1

Work Order ID: 63825



Parent Item: D4093-1

Parent Item Name: Bracket

Start Date: 11/15/10

Required Date: 11/17/10

Start Qty: 2.00

Required Qty: 2.00

Comments: lpp Rev:A New Issue 10-05-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No				f	30.5800	1	2			



6061T6 BAR .750 X 6.00



11-15

Q

Location

Loc Qty

Loc Code

MAT03

30.58

112567

30.58

112567

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

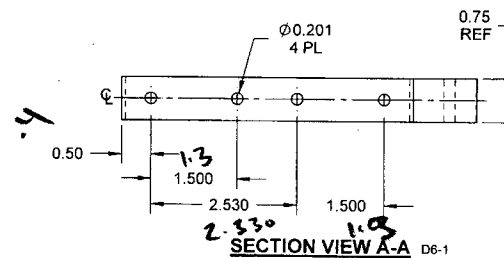
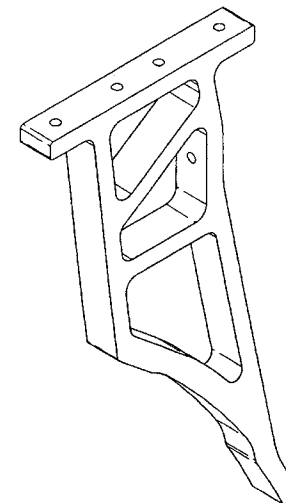
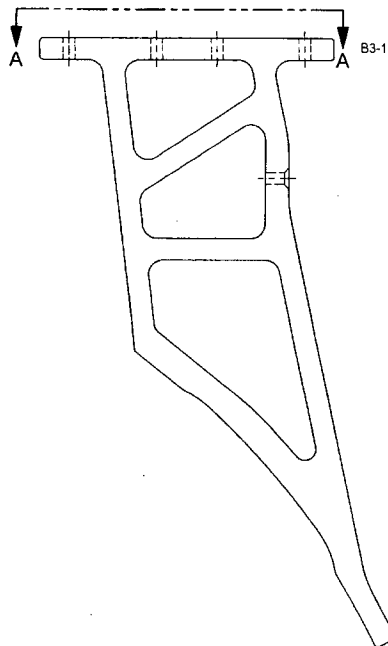
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D4093-1 BRACKET

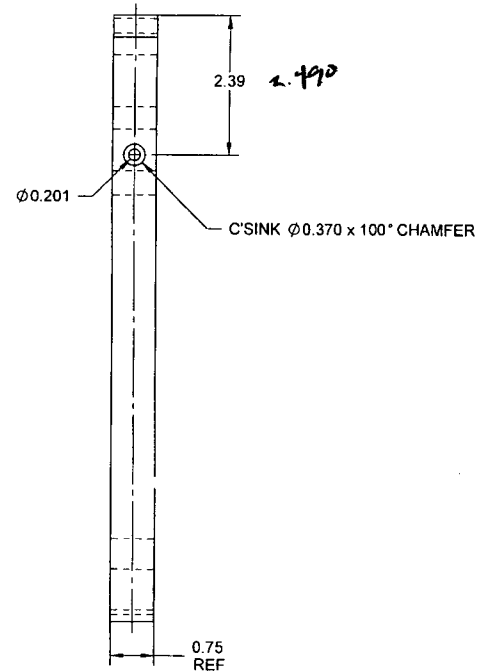
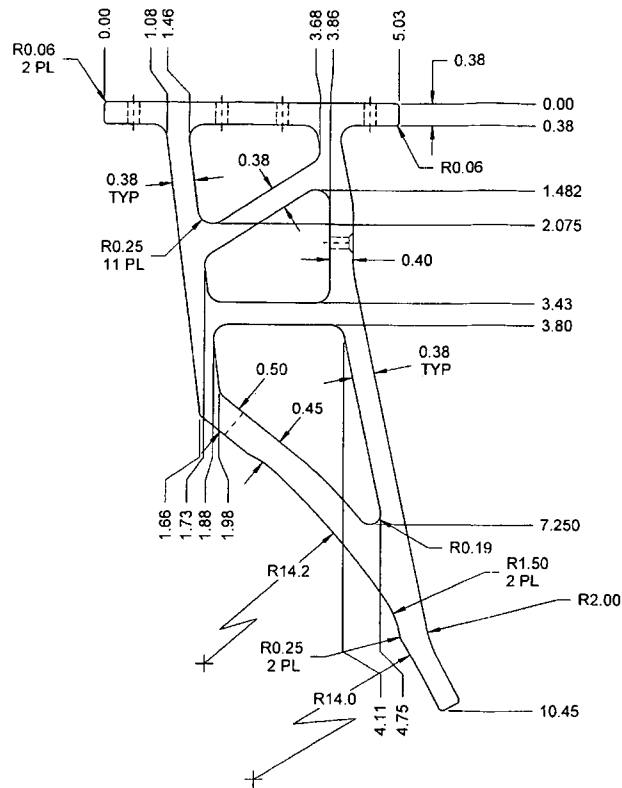
RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/D OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs

alob63825

A		NEW ISSUE		RF	10.09.16
REV.		DESCRIPTION		BY	DATE
DESIGN		RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN		RF			
CHECKED		<i>MP</i>	DRAWING NO.	REV. A	
MFG. APPR.		<i>MP</i>	D4093	SHEET 1 OF 5	
APPROVED		<i>MP</i>	TITLE	SCALE	
DE APPR.		<i>MP</i>	BRACKET	NTS	
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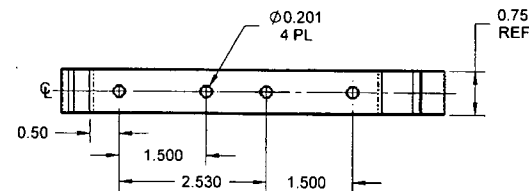
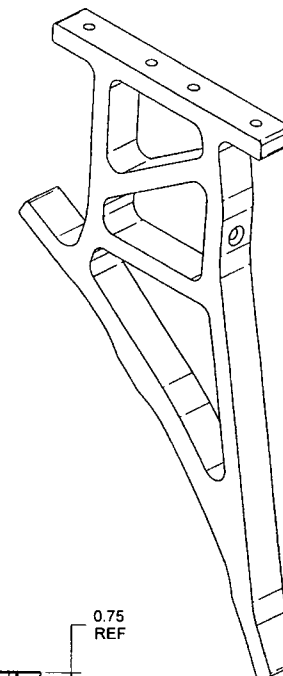
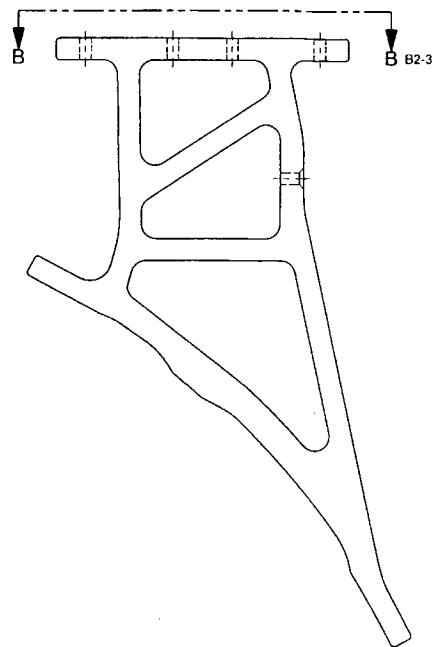


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2010-09-23
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MFG. APPR.	MP	D4093	SHEET 2 OF 5
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63825



D4093-3 BRACKET

SECTION VIEW B-B B5-3

NOTES:

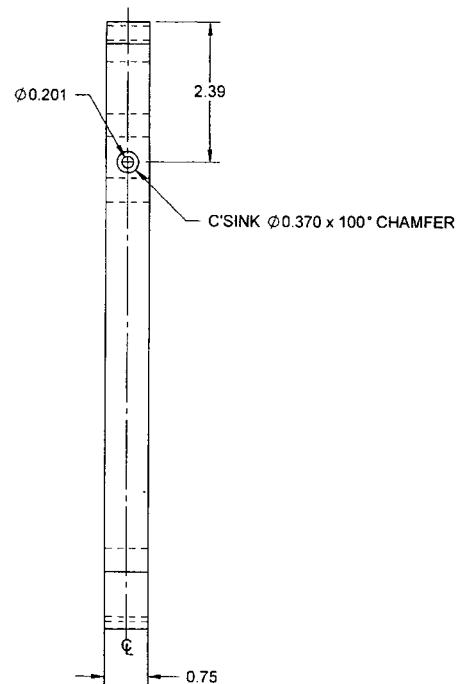
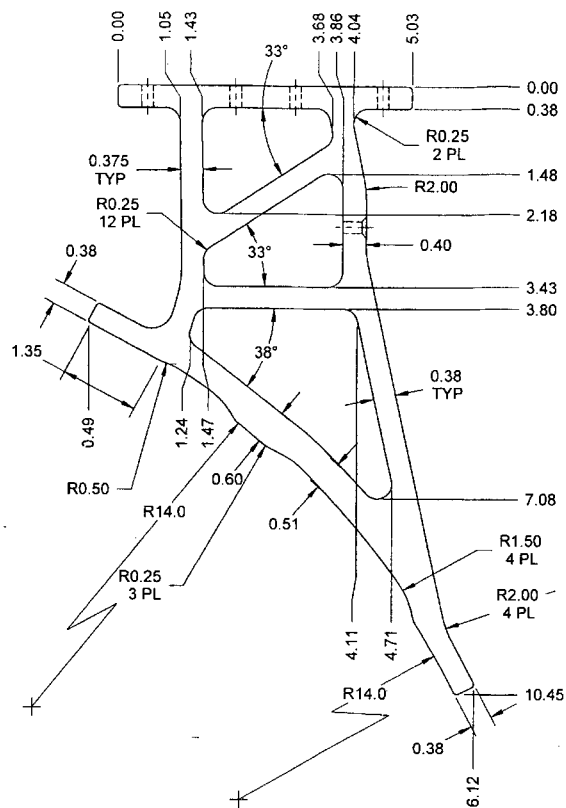
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.96 lbs

63825

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R 2010-09-23

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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4093	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10.09.16	BRACKET	NTS

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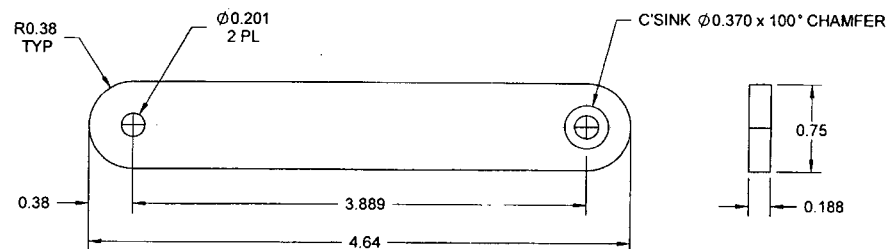


D4093-3 BRACKET

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2010-09-23
JRP

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MFG. APPR.	<i>MD</i>	D4093	SHEET 4 OF 5
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	BRACKET	NTS
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63825



D4093-5 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T68
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

RELEASED
2010-09-23

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4093	REV. A
MFG. APPR.	<i>RF</i>	TITLE BRACKET	SHEET 5 OF 5
APPROVED	<i>RF</i>	SCALE	NTS
DE APPR.	<i>RF</i>	DATE 10.09.16	

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Receiving Report

Date: 9/9/02

Batch No: M112067

Supplier: MAGNA

Dart P/O: 10312

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ 8/29/02 N/A ☐
 Work Order 09/09/02 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061	TGB-200x0400	40	0	0	40	
M6061	630181x0400	40	0	0	40	
M6061	TGB1-200x0400	40	0	0	40	

M6061 TGB-200x0400

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

09/09/02

Location

Received/Costing

RCR 10312

Initial

CY

M 3045126A

64 0 0 69



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10312

Purchase Order Date 9/01/09

PO Print Date 9/01/09

Page Number 1 of 4

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

FAKED
02691010

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

800 363 6646

514 339 1105

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6B0.750X06.000	6061T6 BAR .750 X 6.00	9/04/09 Yes	✓ 60.00 f	Yours ppd 12/9/12	\$10.7500	\$645.00
Special Inst:			MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160 New 40				
2	✓ M6061T6B0.750X01.000	6061-T6 Bar .750 x 1.00	9/04/09 Yes	24.00 f	Yours ppd 12/9/12	\$3.0000	\$72.00
Special Inst:			AS ABOVE				
3	M6061T6B0.187X04.000	6061-T6 Bar .178 x 4.00	9/04/09 Yes	40.00 f	Yours ppd	\$1.7500	\$70.00
Special Inst:			AS ABOVE				
4	✓ M6061T6B0.750X00.750	6061-T6 Bar .750 x .750	9/04/09 Yes	✓ 40.00 f	Yours ppd 12/9/12	\$1.3500	\$54.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

M112567

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 9/01/09

Material Test Report

Customer Ship To:

Magna Stainless Inc.
5775 Kieran St.

St-Laurent

QB H4S 0A3

Our Order: 831165 - 2

Your PO # PO05960

Part # 05873-000-240

Die: LS05873

Description: .750 x 6.000

Alloy Temper 6061 T6

Print Date: 7/31/2009

Chemical Properties

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	others each	others total	Al
0.40-0.8	0.7 max	0.15-40	0.15 max	0.8-1.2	0.04-0.35	0.25 max	0.15	0.05	0.15	remain

Mechanical Properties

Strength ksi

Test ID	Test Date	CastNum	Ultimate	Yield (2% Offset)	Elongation (2" gage length)
1426	7/27/09	09050391A	44.04	40.51	19.5

S
02/07/02

Applicable Specifications: ASTM B221-08 ASTM B308-02 ASTM B429 QQA200/8 QQA200/16

Can Art Aluminum Extrusion Inc. certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Eric Hotte - Tensile Testing

Authorized


Evan Eng, Quality Assurance Mgr.

See w/p 62565